

# Work Order ID 81058

**\*81058\***

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March-07-12 2:25:39 PM

Item ID: D4360-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate Assembly  
 Start Date: 07/03/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 21/03/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4360	B

100 0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg (D4360-1)

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

W 12.03.12 (6)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

**\*110\***

QC

Quality Control

Memo

0.00

W 12.03.12 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 Required Date: 21/03/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130		0.00							
<b>*130*</b>									
Large Fab	Memo	0.00							
Large Fab	1- Weld cups as per dwg A/R S.S. ROD BATCH: <u>M14589</u>								
	2- Apply hardfacing on wearplate as indicated on dwg A/R HARDCOAT 2059B BATCH: <u>m121333</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

5.21.13/12

(46)

X6

12-04-16/BL

5.21.13/17

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 81058

**\*81058\***

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March-07-12 2:25:39 PM

Item ID: D4360-041  
Revision ID:  
Item Name: Wearplate Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Start Date: 07/03/2012 Start Qty: 6.00 **\*6\***  
Required Date: 21/03/2012 Req'd Qty: 6.00 **\*6\***

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				bx	Ø		6/1 12-04-16
160 <b>*160*</b> Packaging Packaging	Identify as per dwg & Stock Location: <b>256</b>  Memo	0.00  0.00				(bx)			12/4/12
170 <b>*170*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							12/4/19 MF 12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

March-07-12 2:25:43 PM

Page 1

Work Order ID: 81058

**\*81058\***

Parent Item: D4360-041

**\*D4360-041\***

Parent Item Name: Wearplate Assembly

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	275.0000	0.97867	6.181074			
<b>*M304S16GA*</b>									**				
304/316 Sheet .063													

Location	Loc Qty	Loc Code
MAT020	275	
119653	19	
120866	96	
120877	160	

D4379-1		Manufactured	No			130	Each	4.0000	12	72			
<b>*D4379-1*</b>									**				
Wearplate Cup													

Location	Loc Qty	Loc Code
WA	4	
79649 X25	4	
81710 X 40		
81059 X 7		

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4360-041	206L/407 WEARPLATE ASSEMBLY
1	1	D4360-1	206L/407 WEARPLATE
2	12	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 81058MLJ  
12/03/07

D4360-041 206L/407 WEARPLATE ASSEMBLY

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4360-041" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.10 lbs
- 8) WELDING: PER QSI 004 B
- 9) 2059B HARDCOAT WELD, 12 PL

**RELEASED**  
2011-05-15  
*MP*

B	SHT 3, LIGHTENING HOLES DELETED, SHT 2 ZONE B.3 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW	AJS	11.05.13
A	NEW ISSUE	AJS	11.03.22
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MP</i>	D4360	SHEET 1 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	206L/407 WEARPLATE ASSEMBLY	NTS
DATE	11.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS SPECIFICALLY DESIGNED BY DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

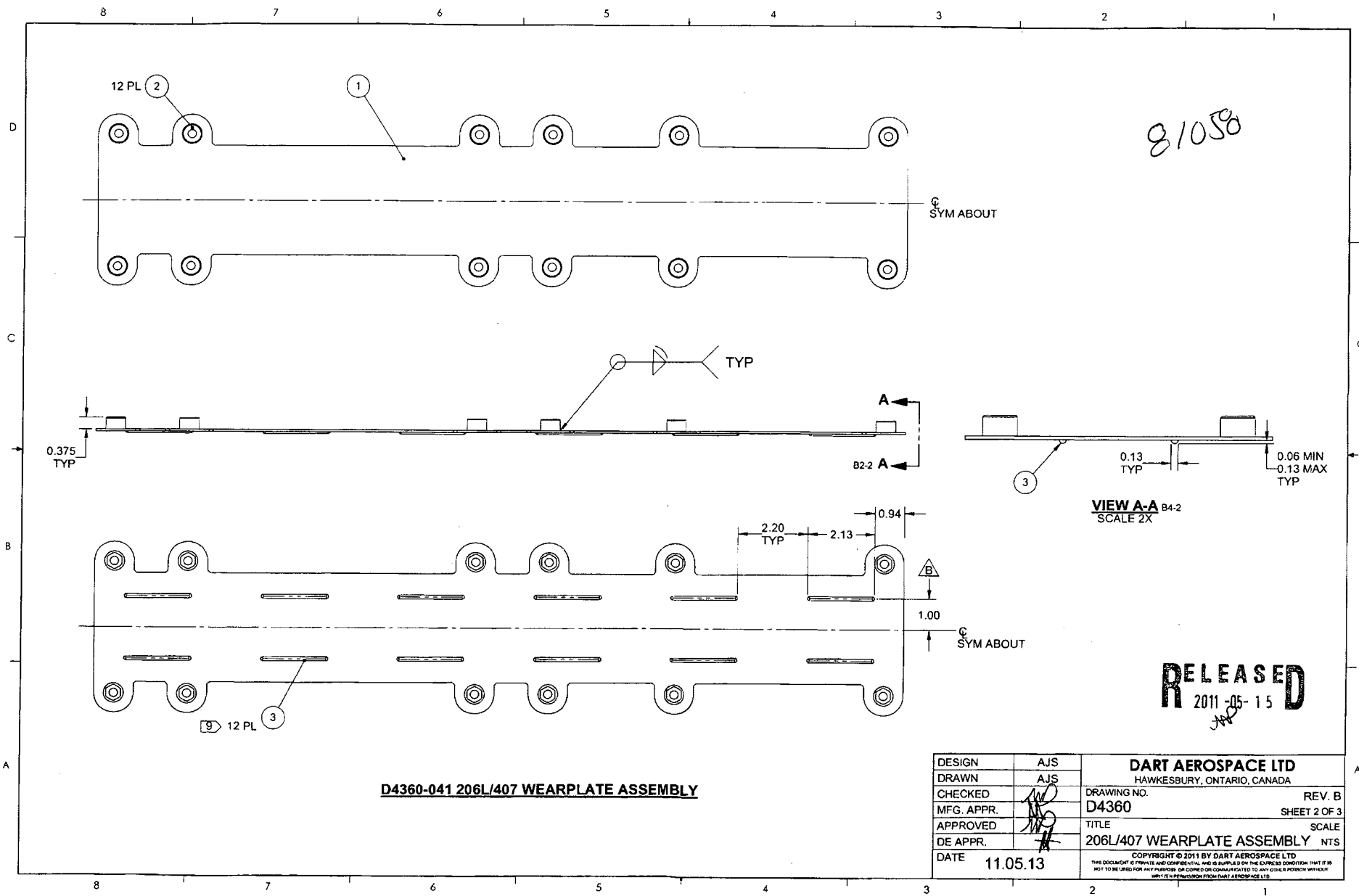
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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
81058



**D4360-041 206L/407 WEARPLATE ASSEMBLY**

**VIEW A-A B4-2**  
SCALE 2X

**RELEASED**  
2011-05-15

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D4360</b>	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		206L/407 WEARPLATE ASSEMBLY NTS	
DE APPR.		SCALE	
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

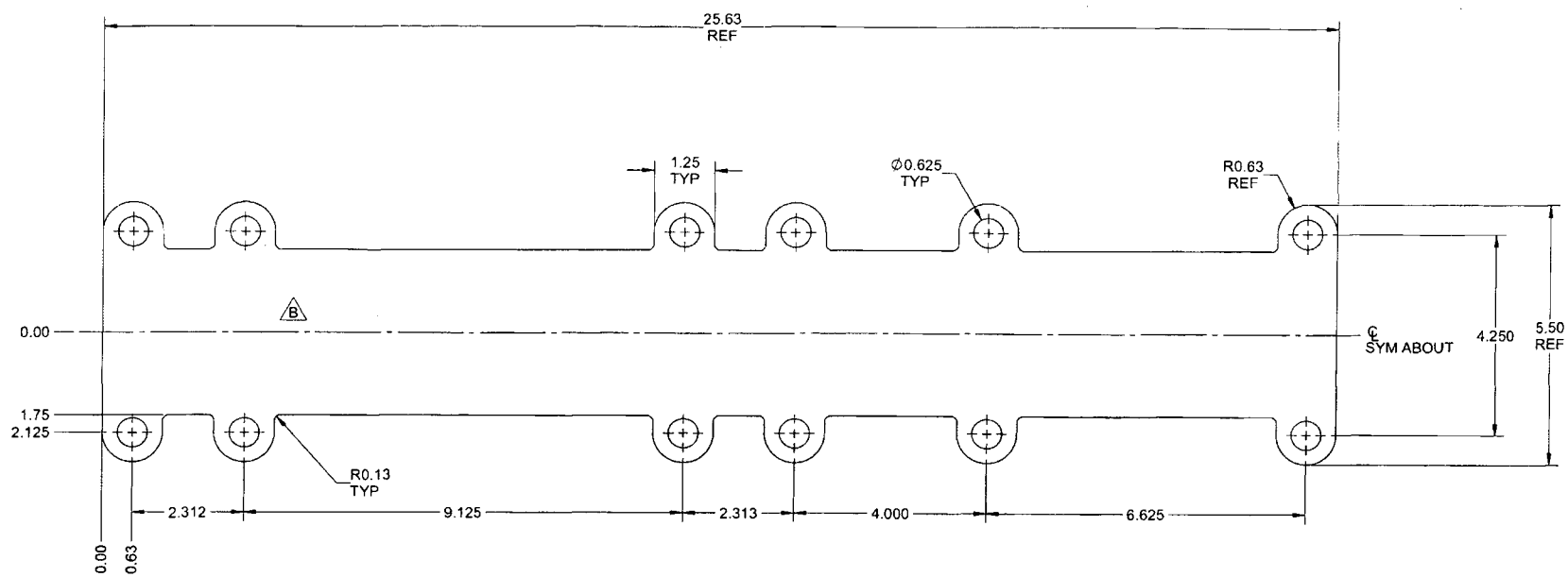
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

81058



**D4360-1 206L/407 WEARPLATE**

**RELEASED**  
2011-05-15  
MP

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH , 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4360	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	206L/407 WEARPLATE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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